

Date: Wednesday, 7/4/2007 3:30:56 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : LEG

Job Number : 33295

Estimate Number : 12907

P.O. Number : N/A

This Issue : 7/4/2007

S.O. No. : N/A

Part Number : D35233

Drawing Number : D3523 UNDER REVIEW

Prsht Rev. : NC

First Issue : N/A

Type : MACHINED PARTS

Project Number : N/A

Drawing Revision : N/A

Previous Run : 32917

Material : N/A

Due Date : 7/11/2007

Qty: ① Um: Each

Written By : *J.M/07-07-12*

Checked & Approved By : _____

Comment : Est Rev:A New Issue 07-06.15 EC

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6R0.750 1.00

6061-T6 Round Bar 0.750" 1.00



Comment: Qty.: 0.0945 f(s)/Unit Total : 0.0945 f(s)

6061-T6 round bar 0.750" 1.000

(M6061T6 round bar 0.750")

Batch: 18147

CERTIFICATE OF CONFORMITY
REQUIRED

2.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Turn as per Dwg D3523

BG 07-07-08

②

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG 07-07-08

②

4.0

QC8

SECOND CHECK



CB

07-07-17

**ENGINEERING
APPROVAL**

Comment: SECOND CHECK

J.L 07/07/08

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Install Heli-coil as per Dwg D3523

1 MS21209F1-20 batch # M104926

J.M/07-07-19

Date: Wednesday, 7/4/2007 3:30:56 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 33295

Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07-07-19

9.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

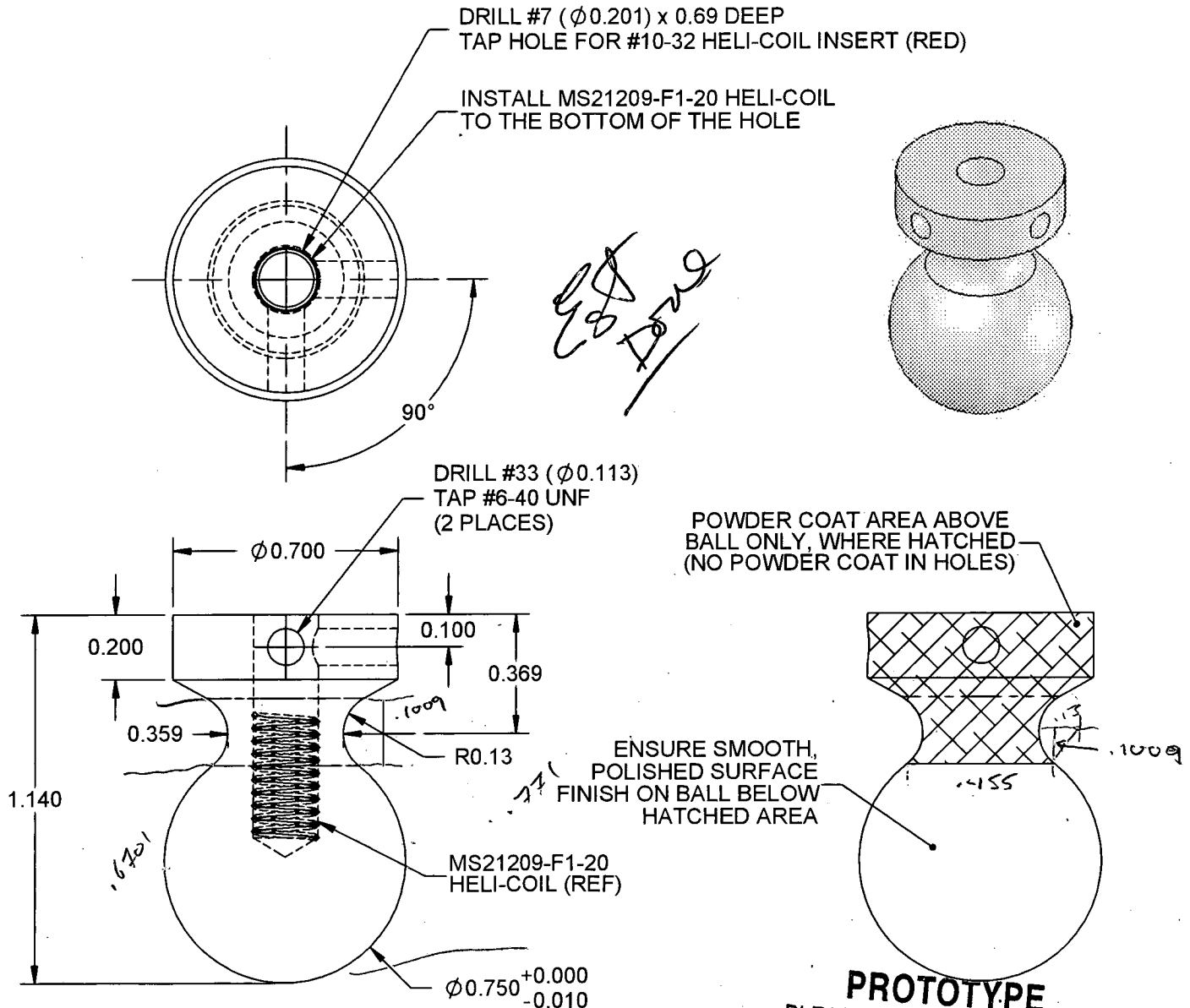
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/07/18

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3523	REV. A SHEET 2 OF 2
DATE 07.06.18	TITLE LEG		SCALE 2:1



D3523-3 LEG

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PART ABOVE BALL SHAPE ONLY (HATCHED AREA, EXCEPT HOLES)
BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

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Receiving Report

Date: 05/07/25
Supplier: Copper & Brass

Batch No: M18147
Dart P/O: 2008385

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐
Q.C. Inspection 200727

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606176B	2.00 x 4.00	24	12		12	

TSR No. _____

Production/Admin: 05/07/28
Date: 2-1385
Received/Costing: 2-1385
Initial: MS
H:\ISO9000\Forms\Purchase\RECREPORT rev B

Initials of receiver (if shipment OK) DC
Accounting: _____
Date: _____
AP/MR: _____
Initial: _____

"Shipping, do not place any packages on ground"

FULL		SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT	
CUSTOMER RECEIVING HOURS				MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT	
BOXES	BARS	CASES	CUSHP	PKGS	SKIDS	BOLS	TUBES	CTNS	FLAT
						1			
INSPECTION									
RECORD									

TEST RESULTS

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

ASTM-B221

AMS-QQ-A-200/8

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
167935 00 210.00 LB KAISER 0C94583 503A

PCS : TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

MARY L. TAYLOR. - General Manager: TORONTO
COPPER AND BRASS SALES CANADA IS A DIVISION OF THYSSENKRUPP MATERIALS, CA. LTD./LÉ

PRINTED 07/15/05 10:16 AM

CONTROL NO 00029

SHIP DATE 07/22/05 SHP		GROSS WEIGHT 238		QUOTE 30-141895-6		OF 14		PACKING LIST	
AEROSPACE		WORK ORDER **		ORDER DATE 07/15/05 ORD		TEST RESULTS			
SHIP TO FRT AEROSPACE 270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7		01		DELIVERY DATE 07/22/05 DEL		SHIP BRANCH 30-TOR		SELL BRANCH 30-TOR	
						WORK ORDER UV2176		6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y	
CUSTOMER P.O. NUMBER 2008385		TERRITORY 01		ENTRY ID 30MAC		CUSTOMER SIGNATURE		DATE	
BUYER LINDA LACELLE		INSIDE SALES MARIO A. CARREIRO		QUANTITY INVENTORY		ORDERED 210.49 LB		SHIPPED 210.00	
BUYER TELEPHONE (613) 632-9577		INSIDE SALES TELEPHONE (905) 696-8100 223		BILLING		228.00 LF		228.00	
SHIP VIA		SHIPPING STATUS		WAREHOUSE					
INTERNAL		COMPLETE X		PARTIAL		CANCEL			
TO CUSTOMER COMMON/FRT-TST		FOB DEST		PACKED WITH OTHER GOODS					
BILL OF LADING		FREIGHT STATUS PPD		FINISHED GOODS LOCATION					
								018542-1	
PART DESCRIPTION									
RD 6061-T6511 EXTR ALUMINUM ROD, 1 NO PROCESSING - 144" ML, Test Results Attn to: QA Department. <i>05/17/05</i>									
SPECIAL INSTRUCTIONS									
"Shipping, do not place any packages or goods on top of our material."									
FULL		SCRAP		FILLED BY SC		PACKED BY		Q/A AUDIT	
CUSTOMER RECEIVING HOURS		MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT			
BOXES	BARS	CASES	CUSHP	PKGS	SKIDS	BOLS	1	TUBES	CTNS
INSPECTION RECORD									

TEST RESULTS

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ASTM-B221

AMS-QQ-A-200/8

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
167935 00 210.00 LB KAISER 0C94583 503A

PCS TAG NO

QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

MARY L. TAYLOR

General Manager: TORONTO

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PRINTED 07/15/05 10:16 AM

CONTROL NO 00029

KAISER ALUMINUM
MATERIAL CERTIFICATION
COPPER & BRASS SALES
6905 KENDERRY GATE UNIT 4
MISSISSAUGA, ON L5T2Y8

PAGE

KAISER ALUMINUM
4111 S 74 E Ave
Tulsa, OK 74145

COPPER & BRASS SALES

SOUTHFIELD MI 48086 C94583 08/17/04
SOLD TO PURCHASE ORDER DATE PRINTED

SOLD TO PURCHASE ORDER DATE PRINTED

018542-1 1.000 PRECIS ROD +/- .004 TOL
CUSTOMER PART NUMBER DESCRIPTION

801378-001 503A 206 6061-T6511B
RELEASE-ITEM LOT ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.
503A 206	0001 0001	53.8	51.0	11.9		N/A
503A 206	0001 0002	53.5	50.6	11.8		N/A
503A 206	0001 0003	53.6	50.6	11.9		N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00

APPLICABLE REQUIREMENTS:

PER ASTM-B221-02, STENCILED
ASME-SB221 1998 SECT II
PER AMS-QQ-A-200/8
UNS#6061
MEETS ALL SPECIFICATION
REQUIREMENTS FOR 6061-T6511
ELEVATED MINIMUM MECHANICAL
PROPERTIES AS FOLLOWS:
UTS=42.0 KSI MIN
YIELD=38.0 KSI MIN
ELONGATION=10.0% MIN

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & condition of sale. Test reports are on file, subject to examination.